

Date: Thursday, 11/23/2006 11:56:18 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT WELDMENT ASS'Y
Job Number	: 29673		
Estimate Number	: 11515		
P.O. Number	: N/A	Part Number	: D34439
This Issue	: 11/23/2006 S.O. No. : N/A	Drawing Number	: D3443 REV. B.
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 28166	Material	: N/A
Written By	: <u>JA</u>	Due Date	: 12/7/2006 Qty: 12 Um: Each
Checked & Approved By	: <u>JA 06 11 23</u>		
Comment	: est rev A 06.12.19 new issue .ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELINR0500	Delrin Round Bar .50"
-----	-------------	-----------------------



Comment: Qty.: 0.0919 f(s)/Unit Total : 1.1025 f(s)

Delrin Round Bar .50"

batch: M102828

DIP 07/01/13

12

2.0	LATHE CONV.	CONVENTIONAL LATHE
-----	-------------	--------------------



Comment: CONVENTIONAL LATHE

1-turn as per dwg D3443

2-deburr

BC / DIP 07/01/13

12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC / DIP 07/01/13

12

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.F. 07/01/05

(11)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: A435

Red 7/01/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/01/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/15	2	Ø, 210" is at, 225"		Scrap, not replace.	J.F. 07/01/15	 07/01/15	 07/01/15	 07/01/15

NOTE: Date & initial all entries

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Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 29673

Part Number: D34439

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



11

Comment: FINAL INSPECTION/W/O RELEASE

207/01/15

Job Completion



207/01/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

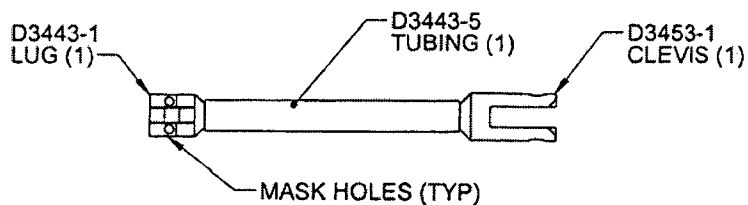
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

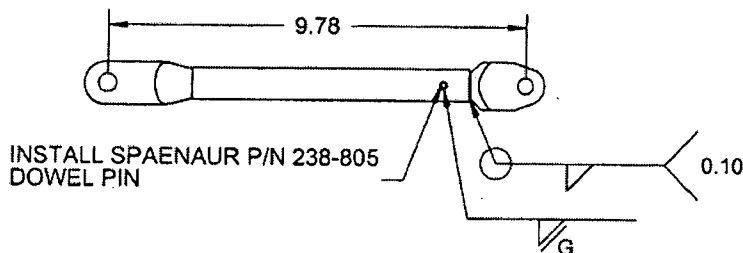
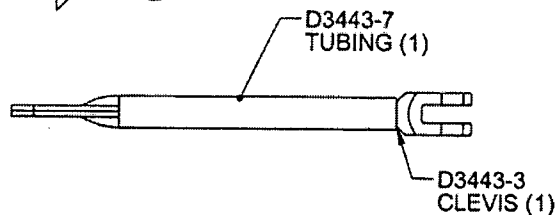
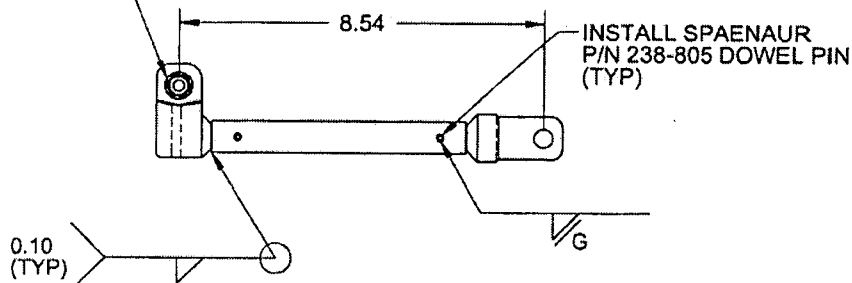
NOTE: Date & initial all entries

DART

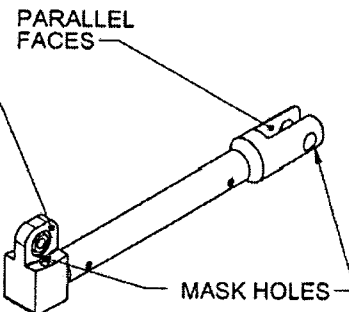
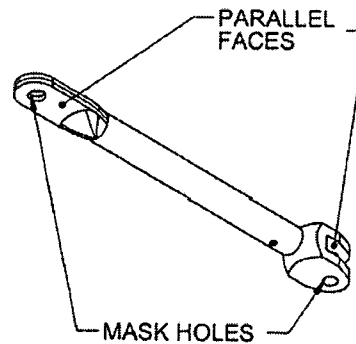
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	

RELEASED05.12.09 *[Signature]*

PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

**D3443-041****D3443-043**

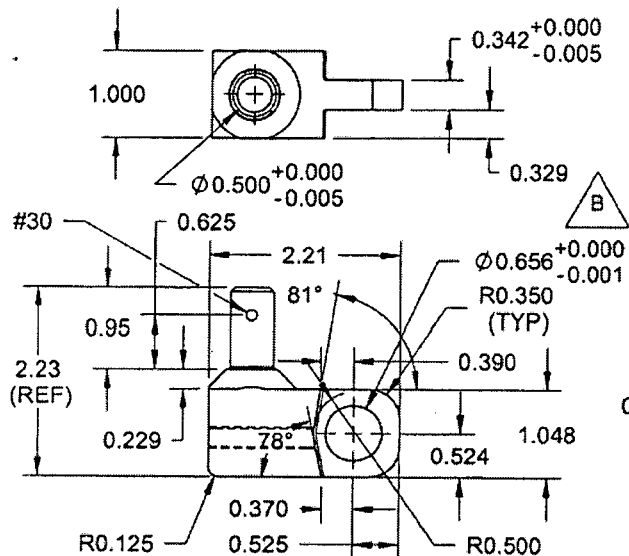
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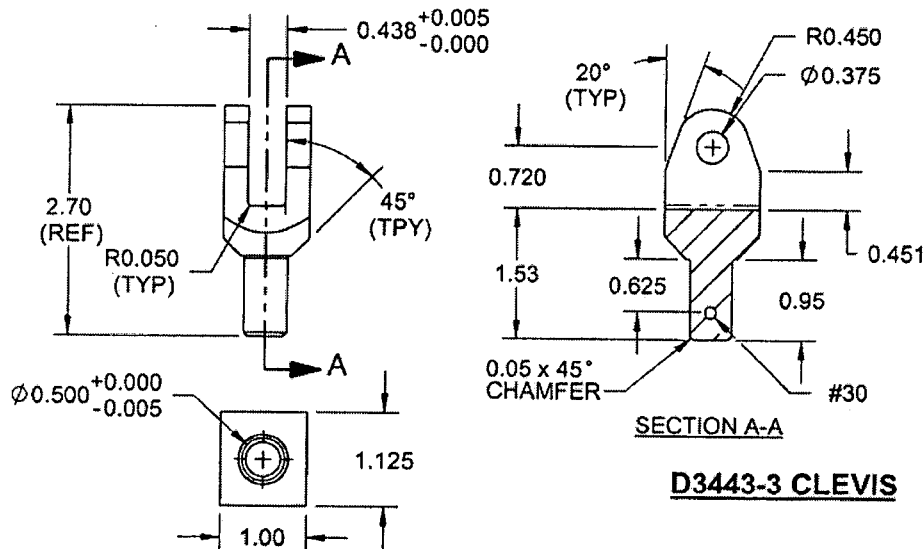
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:2	

**RELEASED**

05.12.04 #

D3443-1 LUG**D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

**D3443-3 CLEVIS****D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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NO **29673**

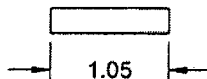
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:2

$\varnothing 0.210^{+0.005}_{-0.010}$

**D3443-9 PIN****D3443-9 NOTES:**

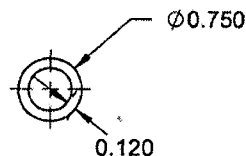
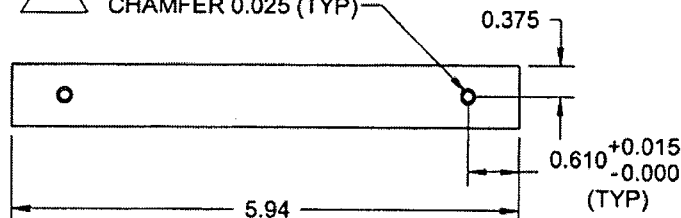
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

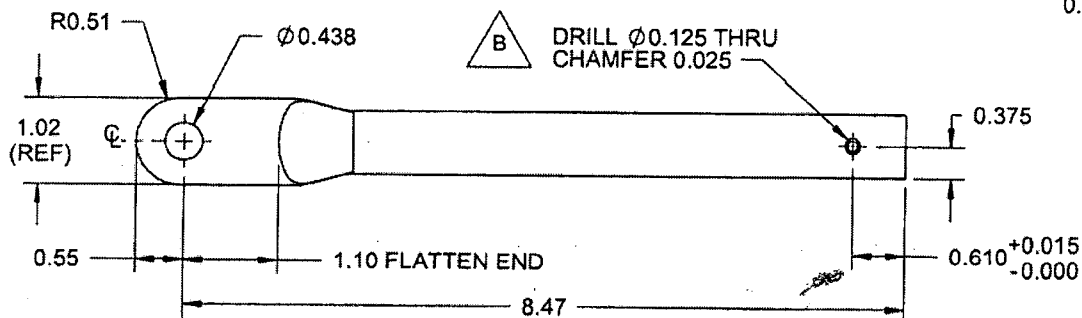
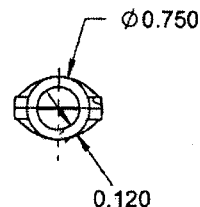
05.12.09



DRILL $\varnothing 0.125$ THRU
CHAMFER 0.025 (TYP)

**D3443-5 TUBING**

$0.260^{+0.000}_{-0.030}$

**D3443-7 TUBING****D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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